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D3639-2

Job Sheet 206098



Part No: D3639-2

Job Qty: 12 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/24/20

Job Tracking No:

Due Date: 2/17/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 07-07-20 JLM Verified By:EC IPP Rev:B remove c'sink DD 10.04.13
verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off						
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time							
100	Waterjet - Flow - 1	12 pcs		2/17/20	0.17	0.92	Waterjet - Flow		OK 20/01/20						
110	QC 2	12 pcs		2/17/20	0.00	0.00	QC 2 - 1								
							QC 2 - 12								
							QC 2 - 14								
							QC 2 - 17								
							QC 2 - 19								
							QC 2 - 2								
							QC 2 - 20								
							QC 2 - 22								
							QC 2 - 23								
							QC 2 - 25								
							QC 2 - 32								
							QC 2 - 33								
							QC 2 - 35								
							QC 2 - 39								
							QC 2 - 4								
							QC 2 - 40								
							QC 2 - 44								
							QC 2 - 45								
							QC 2 - 48		OK 20/01/20						
							QC 2 - 49								
							QC 2 - 50								
							QC 2 - 51								
														QC 2 - 52	
														QC 2 - 57	
							QC 2 - 62								
							QC 2 - 63								
							QC 2 - 8								
							QC 2 - 66								
							QC 2 - 64								
							Plex 1/24/20 9:17 AM Dart.lajeunesse.mar								

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
120	QC 8	12 pcs	2/17/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
140	Small Fab - Brake NC - B4B	12 pcs	2/17/20	0.25 0.26	Small Fab - Brake - 1 - B4B
					Small Fab - Brake - 2 - B4B
					Small Fab - Brake - 3 - B4B
150	QC 5	12 pcs	2/17/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
160	Handfinish - 1-1 Chemical-B4B	12 pcs	2/17/20	0.00 0.78	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B

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9-89

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FEB 13 2020
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					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	QC 7	12 pcs	2/17/20	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
					QC 7 - 79	
					QC 7 - 83	
175	QC 5	12 pcs	2/17/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	

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NOT
REQUIRED

				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180	Packaging 3-1 - Stock - B4B	12 pcs	2/17/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B DAS
					Packaging 3 - 23 - B4B 84
					Packaging 3 - 24 - B4B 9-89
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
190	QC 21 - SA	12 pcs	2/17/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53 DAS

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FEB 07 2020

Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 140 - (Form as per dwg)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 175 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	2.8680 sf (.239 ea)	100-Waterjet - Flow - 1	S237392

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	3	97	0

Part Specifications

Specifications could not be found.

Plex 1/24/20 9:17 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 206098
Description: Doubler		Part Number: D3639-2
Inspection Dwg: D3639 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	0.625	1		V: R-02	
Ø0.191	+0.005/-0.001	0.191	1		Tap	
Ø0.098	+0.004/-0.001	0.098	1			
0.69	+/-0.030	0.688	1			
1.59	+/-0.030	1.591	1			
2.49	+/-0.030	2.495	1			
3.39	+/-0.030	3.384	1			
3.990	+/-0.010	3.985	1			
4.990	+/-0.010	4.991	1			
5.19	+/-0.030	5.191	1			
6.99	+/-0.030	6.99	1			
8.64	+/-0.030	8.639	1			
0.45	+/-0.030	0.451	1			
0.710	+/-0.010	0.711	1			
2.000	+/-0.010	10.999	1			
2.75	+/-0.030	2.749	1			
3.55	+/-0.030	3.552	1			
4.00	+/-0.030	4.000	1			
2.000	+/-0.010	2.000	1			
2.590	+/-0.010	2.591	1			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: N/A
Date: 20/10/20	Date: JAN 30 2020	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S251832



Part: D3639-2

Job No: 206098

Serial No/Batch: S251832

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/29/20